DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-026045
Date Inspected: 09-Jul-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name:	N/A		**CWI Present:**	☐ Yes ☑ No	
Inspected CWI report:	☐ Yes	☐ No ☑ N/A	**Rod Oven in Use:**	☐ Yes ☐ No	☑ N/A
Electrode to specification:	☐ Yes	☐ No ☑ N/A	**Weld Procedures Followed:**	☐ Yes ☐ No	☑ N/A
Qualified Welders:	☐ Yes	☐ No ☑ N/A	**Verified Joint Fit-up:**	☐ Yes ☐ No	☑ N/A
Approved Drawings:	☐ Yes	☐ No ☑ N/A	**Approved WPS:**	☐ Yes ☐ No	☑ N/A
			Delayed / Cancelled:	☐ Yes ☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG Trial Assembly

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) at Trial Assembly Areas

Cross Beam (CB) # 19 to Segment 14 West

This QA Inspector performed Dimension Control Inspection along with Caltrans QA Inspector for measuring offset between the stiffeners at floor beam (FL3) extension at Segment 14 West to Cross Beam # 19 stiffeners at bottom panel, vertical web plate and deck plate at following locations:

At Panel Point (PP) 125, Segment 14 West offset measurement performed between floor beam stiffeners to west side Vertical Web Plate stiffeners of cross beam # 14 total 13 stiffeners.

At Panel Point (PP) 126, Segment 14 West offset measurement performed between floor beam stiffeners to centre Vertical Web Plate stiffeners of cross beam # 14, total 13 stiffeners.

At Panel Point (PP) 127, Segment 14 West offset measurement performed between floor beam stiffeners to east side Vertical Web Plate stiffeners of cross beam # 14, total 13 stiffeners.

Between Panel Points (PP) 125 to PP 126, Segment 14 West offset measurement performed between deck panel stiffeners to deck panel stiffeners of cross beam # 14, total 11 stiffeners.

Between Panel Points (PP) 126 to PP 127, Segment 14 West offset measurement performed between deck panel stiffeners to deck panel stiffener of cross beam # 14, total 11 stiffeners.

Between Panel Points (PP) 125 to PP 126, Segment 14 West offset measurement performed between bottom panel stiffeners to bottom panel stiffeners of cross beam # 14, total 5 stiffeners.

Between Panel Points (PP) 126 to PP 127, Segment 14 West offset measurement performed between bottom panel stiffeners to bottom panel stiffener of cross beam # 14, total 5 stiffeners.

Note: The offset between the stiffener recorded out of tolerances, ZPMC and ABF wants to adjust all the offsets at field i.e., Bay Area, U.S.A.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

Segment 13BW to Segment 13CW (Full Height Longitudinal Diaphragm to Longitudinal Diaphragm)

This QA Inspector performed Dimension Control Inspection on the Full Height Longitudinal Diaphragm to Longitudinal Diaphragm at Work Point W3 (Counter Weight side) and at Work Point W4 (Cross Beam side) for the Segment 13BW to Segment 13CW between Panel Point (PP) 122 to PP 122.5 at the following locations:

The offset was measured at 8 (Eight) different Elevations at vertical web plates.

At Elevation 20mm from the Bottom Panel.

At Elevation 1700mm from the Bottom Panel.

At Elevation 2000mm from the Bottom Panel.

At Elevation 3400mm from the Bottom Panel.

At Elevation 3600mm from the Bottom Panel.

At Elevation 4600mm from the Bottom Panel.

At Elevation 4800mm from the Bottom Panel.

At Elevation 5400mm from the Bottom Panel.

The QA Inspector measured the Offset using 1(One) Meter Straight Edge.

The Sweep was measured at 100 mm and 500mm from Floor Beam at Panel Points (PP) 122 and from PP 122.5 at Center (Total 5 Locations) using string line at Elevation 1700mm and 2800mm from Bottom Panel.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

Segment 13BE to Segment 13CE (Full Height Longitudinal Diaphragm to Longitudinal Diaphragm)

This QA Inspector performed Dimension Control Inspection on the Full Height Longitudinal Diaphragm to Longitudinal Diaphragm at Work Point E3 (Bike Path side) and at Work Point E4 (Cross Beam side) for the Segment 13BE to Segment 13CE between Panel Point (PP) 122 to PP 122.5 at the following locations:

The offset was measured at 8 (Eight) different Elevations at vertical web plates.

At Elevation 20mm from the Bottom Panel.

At Elevation 1700mm from the Bottom Panel.

At Elevation 2000mm from the Bottom Panel.

At Elevation 3400mm from the Bottom Panel.

At Elevation 3600mm from the Bottom Panel.

At Elevation 4600mm from the Bottom Panel.

At Elevation 4800mm from the Bottom Panel.

At Elevation 5400mm from the Bottom Panel.

The QA Inspector measured the Offset using 1(One) Meter Straight Edge.

The Sweep was measured at 100 mm and 500mm from Floor Beam at Panel Points (PP) 117 and from PP 117.5 at Center (Total 5 Locations) using string line at Elevation 1700mm and 2800mm from Bottom Panel.

The measurements were recorded out of tolerance, asked ZPMC to fix the out of tolerance areas and re-offer after rectifications.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations were reported on this date.

WELDING INSPECTION REPORT

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Math,Manjunath	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer